








Derev 55358

# Work Order ID 53491

November 06, 2009 8:50:15 AM

Page 1

Item ID:	D3954-1	Accept		Setup	Start	
Revision ID:	B				Stop	
Item Name:	GWT Pin					
Start Date:	11/6/2009	Start Qty:	10.00		Cust Item ID:	
Required Date:	11/13/2009	Req'd Qty:	10.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3954	B

170 0.00



Hand Finish

Hand Finishing

Memo

PULL FROM STOCK D3954-1  
B 48633X 10

SCUFF TO REMOVE RED PAINT FROM BOLTS

-mf

09.11.06

→ JH 09/11/18 (X10)

180 0.00



Spray Paint

Spray Painting

Memo

1 SPRAY PAINT YELLOW AS PER DWG  
A/R BATCH: 111354J

0.00 Powder coat Hybrid Yellow HS 112 Y12 (Ref PAR 10-01-07)

Start: 2:00pm Temp: 320°F Stop: 2:30pm

(X10) JH 10/01/11

QC14- Inspect Spray Paint



QC

Quality Control

Memo

BR 10-01-11

(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 53491**

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Item ID: D3954-1

Accept



Setup Start



Revision ID: B

Item Name: GWT Pin

Stop



Start Date: 11/6/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 11/13/2009 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

200

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

0.00

Packaging

ID AND STOCK UNDER NEW BATCH NUMBER

10/01/13 (10)

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/01/14

MF 10-1-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

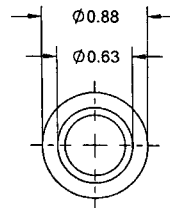
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

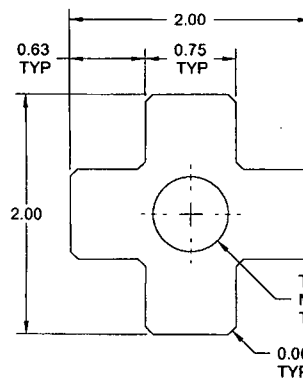
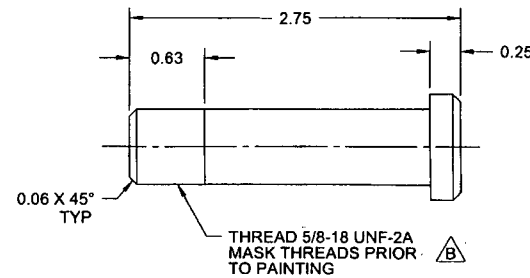
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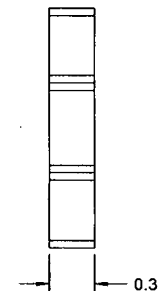
#53491



**D3954-1 GWT PIN**



**D3954-3 GWT KNOB**



**NOTES:**

1) MATERIAL -1: AISI 1010-1025 MILD STEEL ROUND BAR  
PER DART SPEC M1018-R

-3: AISI 1010-1025 MILD STEEL SHEET  
PER DART SPEC MS1010-S

OR: AISI 1010-1025 MILD STEEL BAR  
PER DART SPEC M1010-B

**ALTERNATE MATERIAL:**

-1: AISI 303/304 STAINLESS STEEL ROUND BAR  
REF DART SPEC M303/304R

-3: AISI 303/304 STAINLESS STEEL SHEET  
REF DART SPEC M303/304S

OR: AISI 303/304 STAINLESS STEEL BAR  
REF DART SPEC M303/304B

- 2) FINISH: SPRAY PAINT YELLOW WITH BERTRAND CG-10318 PER DART QSI 005.4.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3954-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -1: 0.26 lbs  
-3: 0.23 lbs

Powder coat hybrid yellow HS112 Y12  
Ref. PAR 10-001 710-07-07  
10-01-07

**RELEASED**  
R 2009 -10- 19  
MP

DESIGN	AJS/DSTOW	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3954	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.	N/A	MISC MACHINED PARTS GWT KIT	NTS
DATE	09.10.15	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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